

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000521**Date Inspected:** 25-Sep-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use: Yes No N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed: Yes No N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up: Yes No N/A
Approved Drawings:	Yes	No	N/A	Approved WPS: Yes No N/A
				Delayed / Cancelled: Yes No N/A
Bridge No:	34-0006	Component:	Welder Qualification Test Plates	

Summary of Items Observed:

This Quality Assurance Inspector reviewed a total of 58 welder qualification film. No discrepancies were noted. There were six films which had dark areas on the film with no write up on the ZPMC Radiographic Reports so the plates had to be found and brought back to the office for comparison. All the areas were found to be undercut or voids, none of which exceed the 1 millimeter maximum depth allowance.

This Quality Assurance Inspector prepared a Non-conformance Report (TL-15) for defects as found by ultrasonic testing having a cumulative length exceed 10% or the weld length. See TL-15 dated September 25, 2007 for details.

Summary of Conversations:

A conversation was held with Mr. Kevin Carpenter of American Bridge/Fluor about the radiographic film which was reviewed today. Mr. Carpenter stated that the indications on the film were not slag or porosity, but pits and undercut. When asked if he had measured any of them for depth he stated that he had not. It was decided to go obtain the plates in question and measure the pits and and undercut for acceptance/rejection status.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

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Inspected By: Berger, Bruce

Quality Assurance Inspector

Reviewed By: Cochran, Jim

QA Reviewer